

Split

Work Order ID 136633-1

136633

Page 1

Thursday, September 03, 2015 8:18:26 AM

Item ID: D4711-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Expandable Pin Assembly, Modified

Start Date: 9/1/2015

Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/1/2015

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: ML5

Date:

SEP 04 2015

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4711

C

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

FF

OCT 01 2015

120

0.00

120

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG (see note 8,9,10)
 ***DO NOT OVERTIGHTEN THE SHAFT INTO THE BARREL PER NOTE
 10***

2

FF

OCT 01 2015

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

DAS
30
9-89

2

OCT 01 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 136633

136633

Page 2

Thursday, September 03, 2015 8:18:26 AM

Item ID: D4711-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Expandable Pin Assembly, Modified
Start Date: 9/1/2015 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 9/1/2015 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>GA</u>	0.00			DAS				
140					30				
Packaging	Memo	0.00			9-89	<u>2</u>			OCT 01 2015
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

Sta 20151001

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
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OTHER : _____																					

Picklist Print

Thursday, September 03, 2015 8:18:30 AM

Page 1

Work Order ID: 136633

136633

Parent Item: D4711-041

D4711-041

Parent Item Name: Expandable Pin Assembly, Modified

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B
13.03.11 AS PER DWG REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4711-043 *D4711-043* Expandable Pin Assembly		Manufactured	No			110	Each	6.0000	1	6			
										**		BAS 27 9-89	
Location ST124 135717 Loc Qty 6 6 Loc Code B135537													
D4726-1 *D4726-1* Handle		Manufactured	No			110	Each	2.0000	1	6			
										**		BAS 27 9-89	
Location ST125 134539 Loc Qty 2 2 Loc Code													
D4727-041 *D4727-041* Barrel		Manufactured	No			110	Each	2.0000	1	6			
										**		BAS 27 9-89	
Location ST125 134510 Loc Qty 2 2 Loc Code B135586													
D4749-1 *D4749-1* Spacer		Manufactured	No			110	Each	12.0000	1	6			
										**		BAS 27 9-89	
Location ST126 134892 Loc Qty 12 12 Loc Code													

OCT 01 2015

DQA: _____ Date: _____



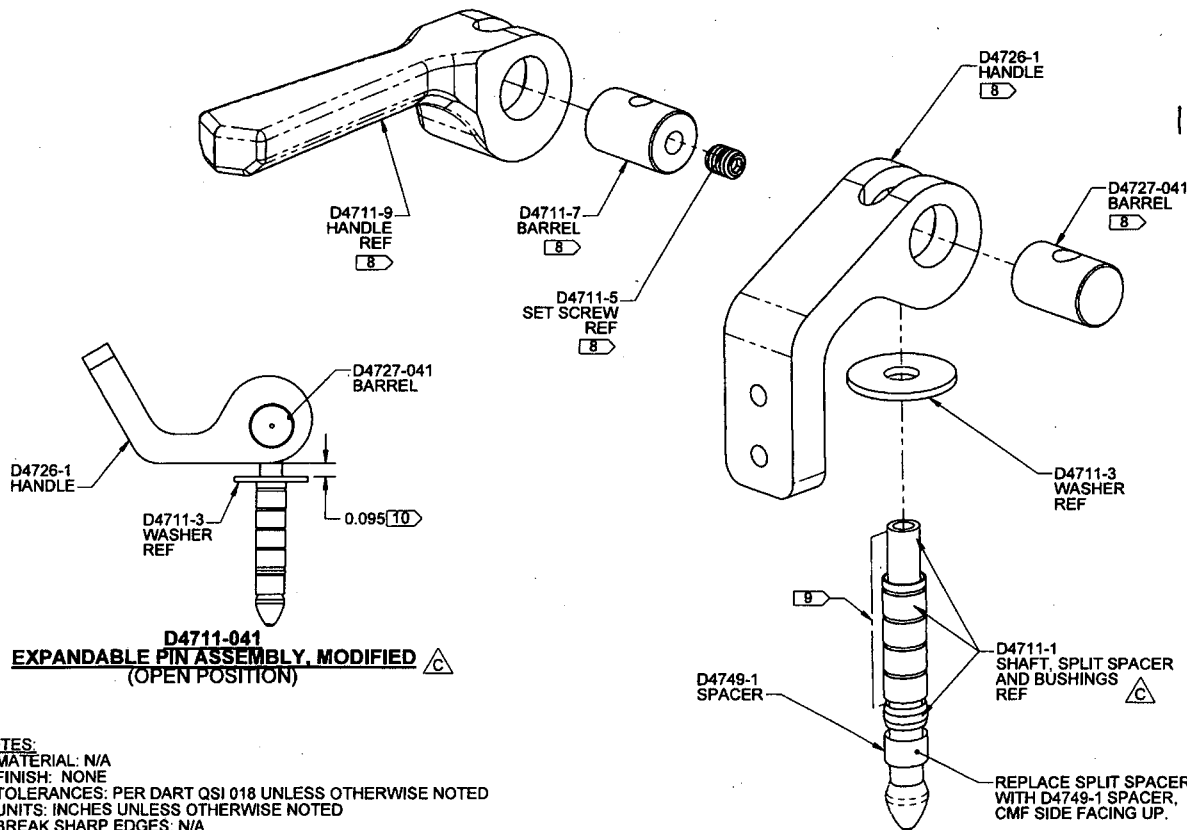
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QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																											
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4711-041	EXPANDABLE PIN ASSY, MODIFIED
1	1	D4711-043	EXPANDABLE PIN ASSY
2	1	D4726-1	HANDLE
3	1	D4727-041	BARREL
4	1	D4749-1	SPACER



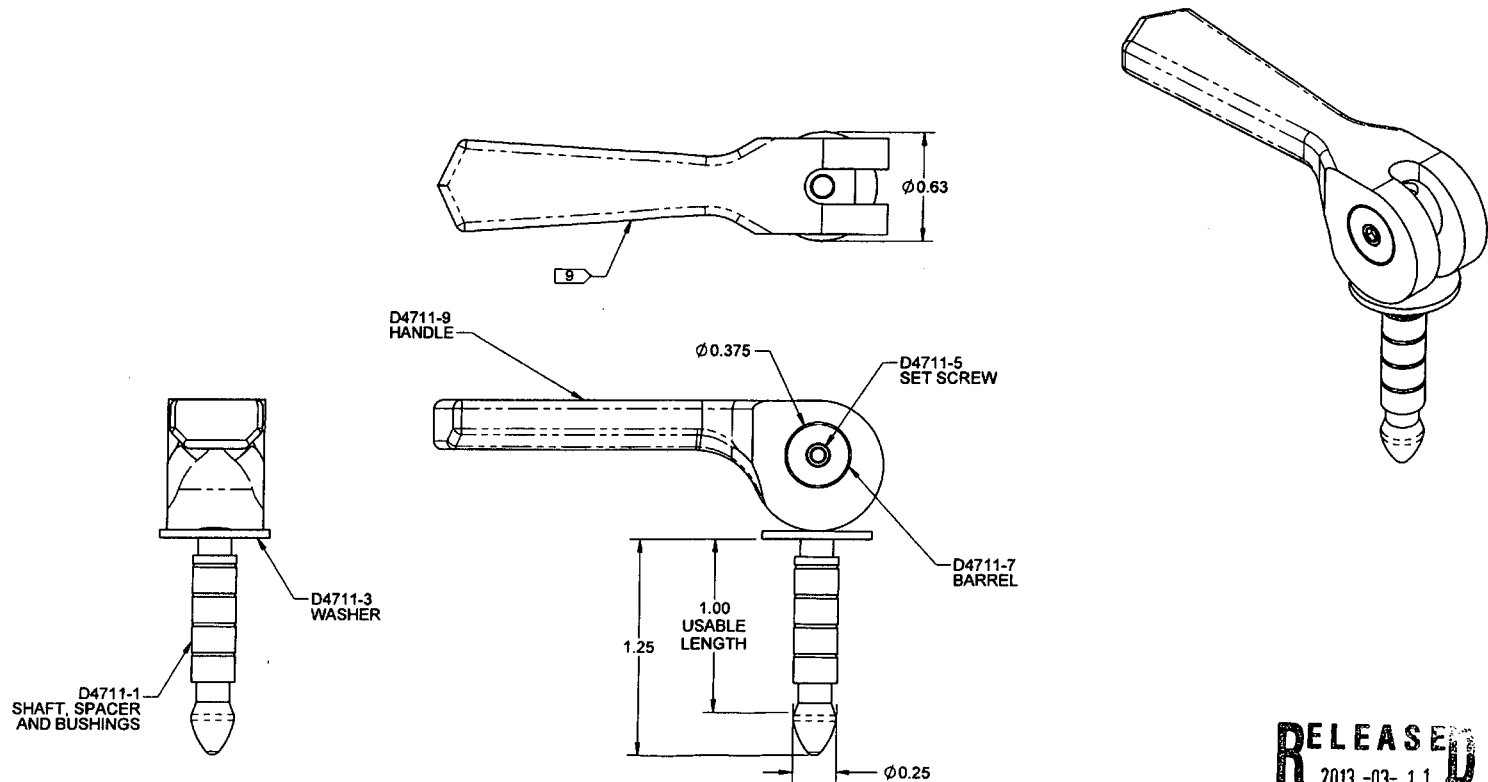
**D4711-041
EXPANDABLE PIN ASSEMBLY, MODIFIED
(CLOSED POSITION)**

RELEASED
2013-03-11

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4711-041" AND B/N "BXXXXX" PER QSI 044 6.7
 - 7) WEIGHT: 0.19 lbs
 - 8) REPLACE D4711-9 HANDLE WITH DART D4726-1 HANDLE.
REPLACE D4711-7 BARREL WITH DART D4727-041 BARREL.
REPLACE BOTTOM SPLIT SPACER WITH D4749-1 SPACER.
DISCARD D4711-5 SET SCREW, D4711-7 BARREL, D4711-9 HANDLE, BOTTOM SPLIT SPACER.
 - 9) WHEN INSTALLING D4749-1 SPACER, ENSURE THAT ALL RETAINED SPLIT SPACERS AND BUSHINGS REMAIN IN THEIR ORIGINAL SEQUENCE AND ORIENTATION.
 - 10) INSTALL THE D4711-1 SHAFT WITH THE ASSEMBLY IN THE OPEN POSITION, UNTIL A GAP OF 0.095" EXISTS BETWEEN THE D4711-3 WASHER AND THE D4726-1 HANDLE. DO NOT OVERTIGHTEN THE SHAFT INTO THE D4727-041 BARREL.

C	REVISED NOTE (A4-1) & NOTE 8, ADDED NOTE 10. PICTORIAL UPDATE, ADDED VIEW B8-1.	AP	13.02.12
B	ADDED D4749-1 SPACER, MODIFIED NOTES 8 AND 9	AP	12.11.23
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	8/	D4711	SHEET 1 OF 2
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	ADJUSTABLE DIAMETER PIN	NTS
DATE	13.02.12	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SPECIFICATION CONTROL DRAWING



D4711-043 EXPANDABLE PIN ASSY

NOTES:

- 1) MATERIAL: CORE PIN, SPLIT RINGS & BARREL: STAINLESS STEEL 17-4 PH CONDITION H925 PER AMS 5643
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) RECOMMENDED SUPPLIER: MCMASTER CARR P/N 97787A661
- 9) HANDLE, BARREL AND SET SCREW TO BE DISCARDED AT NEXT HIGHER ASSEMBLY

RELEASED
2013-03-11

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>al</i>	D4711	SHEET 2 OF 2
APPROVED	<i>al</i>	TITLE	SCALE
DE APPR.	<i>al</i>	ADJUSTABLE DIAMETER PIN	NTS
DATE	13.02.12	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	